

Work Order ID 81170

81170

Page 1

March-12-12 8:37:02 AM

Item ID: D4034-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Upper Rib Assembly

Start Date: 09/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 19/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/12 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D4034

B

100 Weld per dwg A/R S.S. rod Batch 1115778 0.00

100

Large Fab

Memo

0.00

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564

2- Weld bushing in rib and grind weld flush as per dwg

12.04.08 6

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

12.04.10

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

5/2/10

6

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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NOTE: Date & initial all entries

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Upper Rib Assembly

Start Date: 09/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 19/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: B.C.

0.00


130

Packaging

Memo

0.00

Packaging

 12.04.10 @

140

QC21- Final Inspection - Work Order Release

0.00

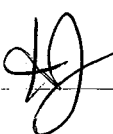
140

QC

Memo

0.00

Quality Control

12/4/10 

12.04.10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

March-12-12 8:37:06 AM

Page 1

Work Order ID: 81170

81170

Parent Item: D4034-041

D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 09/03/2012

Required Date: 19/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER
DWG REV.B DD VERF:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|-----------|--|--------------|----|--|--|-----|------|--------|----|---|--|-----|----------|
| D4034-1 | | Manufactured | No | | | 100 | Each | 8.0000 | 1 | 1 | | | |
| *D4034-1* | | | | | | | | | ** | | | SAD | 12-04-05 |
| Rib | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

| | | |
|-------|---|--------|
| WA006 | 8 | |
| 78262 | 8 | B81467 |

| | | | | | | | | | | | | | |
|-----------|--|--------------|----|--|--|-----|------|--------|----|---|--|-----|----------|
| D4034-3 | | Manufactured | No | | | 100 | Each | 6.0000 | 1 | 1 | | | |
| *D4034-3* | | | | | | | | | ** | | | SAD | 12-04-05 |
| Rib | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

| | | |
|-------|---|--------|
| WA006 | 6 | |
| 79420 | 6 | B82394 |

| | | | | | | | | | | | | | |
|-----------|--|--------------|----|--|--|-----|------|---------|----|---|--|-----|----------|
| D4021-7 | | Manufactured | No | | | 100 | Each | 10.0000 | 1 | 1 | | | |
| *D4021-7* | | | | | | | | | ** | | | SAD | 12-04-05 |
| Hoop | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

| | | |
|-------|----|---------|
| WA005 | 10 | |
| 79877 | 10 | B 81466 |
| | | B81184 |

| W/O: | | WORK ORDER CHANGES | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 2

March-12-12 8:37:06 AM

Work Order ID: 81170

81170

Parent Item: D4034-041

D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 09/03/2012

Required Date: 19/03/2012

Start Qty: 1.00

Required Qty: 1.00

D4021-9

Manufactured No

100

Each

50.0000

4

4

D4021-9

SAD 12-04-05

Bushing

Location

Loc Qty

Loc Code

WA005

50

66437

2

70333

4

72482

4

74966

40

B81584

24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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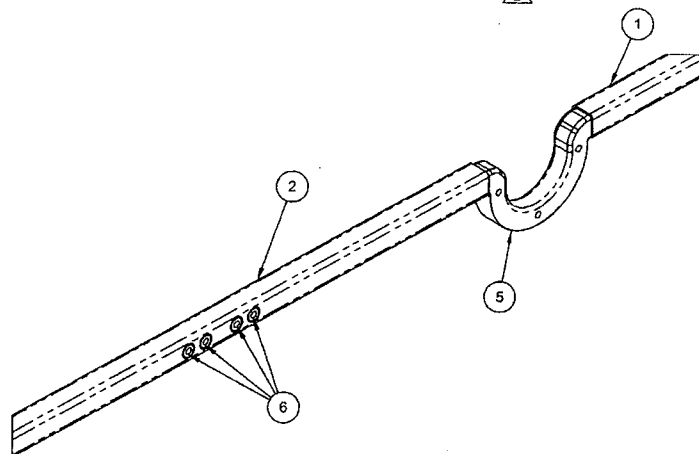
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

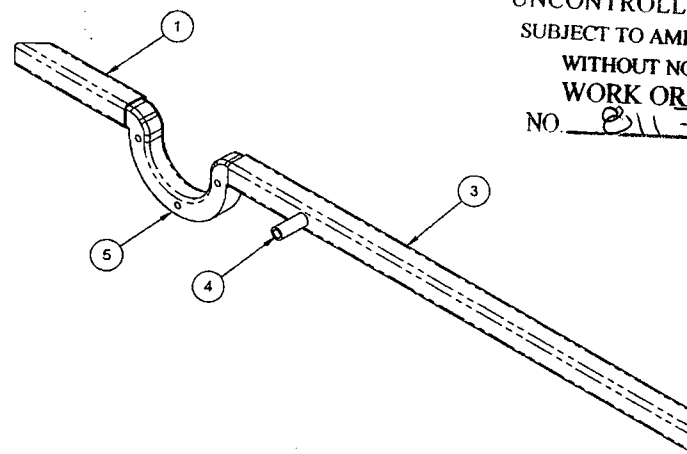
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NOTE: Date & initial all entries

| ITEM | QTY -041 | QTY -043 | P/N | DESCRIPTION |
|------|-------------|-------------|-----------|--------------------|
| | X | | D4034-041 | AFT UPPER RIB ASSY |
| | | X | D4034-043 | FWD UPPER RIB ASSY |
| 1 | 1 | 1 | D4034-1 | RIB |
| 2 | 1 | | D4034-3 | RIB |
| 3 | | 1 | D4034-5 | RIB |
| 4 | | 1 | D2327-3 | SPACER BUSHING |
| 5 | 1 | 1 | D4021-7 | HOOP |
| 6 | 4 | | D4021-9 | BUSHING |



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81170 MJS
12/03/12

RELEASED
2011-01-18
MB

| | | | |
|------------|---------------------------------------|--|--------------|
| B | ADDITIONAL HOLES ADDED ON D4034-3 RIB | SC | 10.12.20 |
| A | NEW ISSUE | AJS | 10.03.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | B | DRAWING NO. | REV. B |
| MFG. APPR. | MB | D4034 | SHEET 1 OF 4 |
| APPROVED | MB | TITLE | SCALE |
| DE APPR. | MB | UPPER RIB ASSY, BASKET BASE | NTS |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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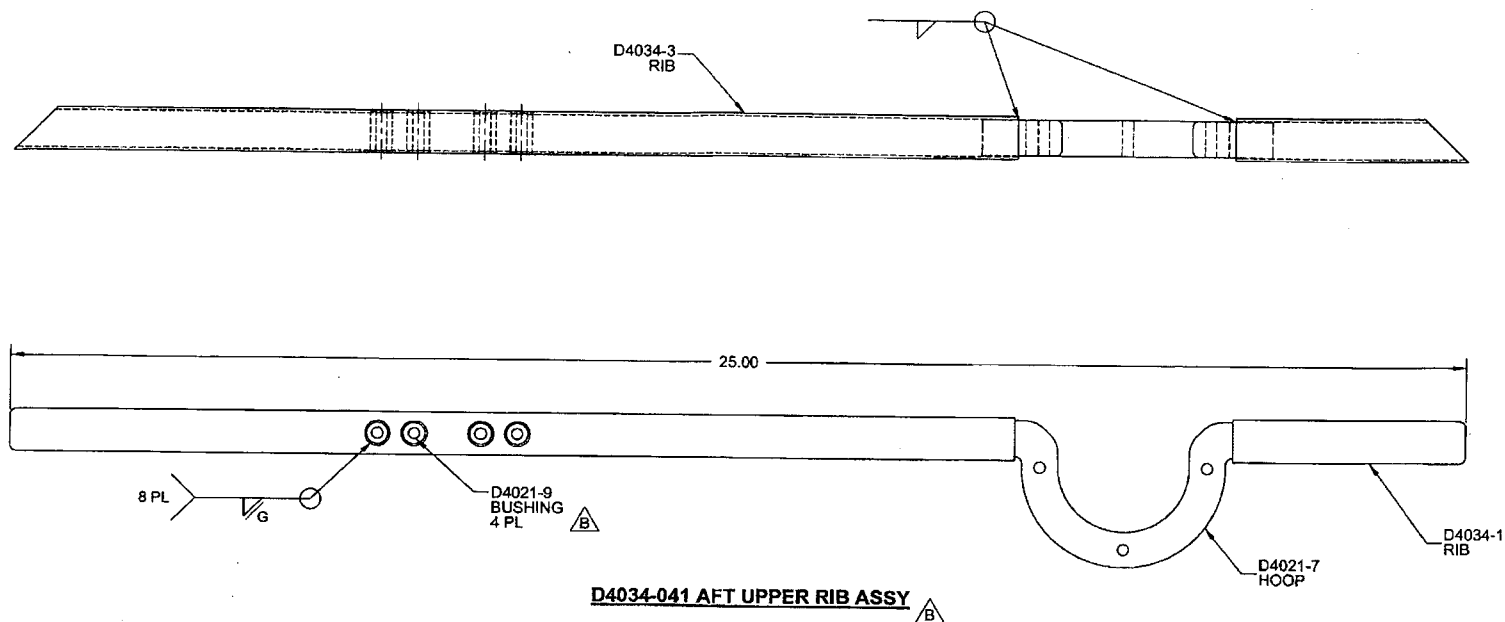
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NOTE: Date & initial all entries

81170



RELEASED
2011-01-18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

| | | | |
|------------|----------|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | B | DRAWING NO. | REV. B |
| MFG. APPR. | | D4034 | SHEET 2 OF 4 |
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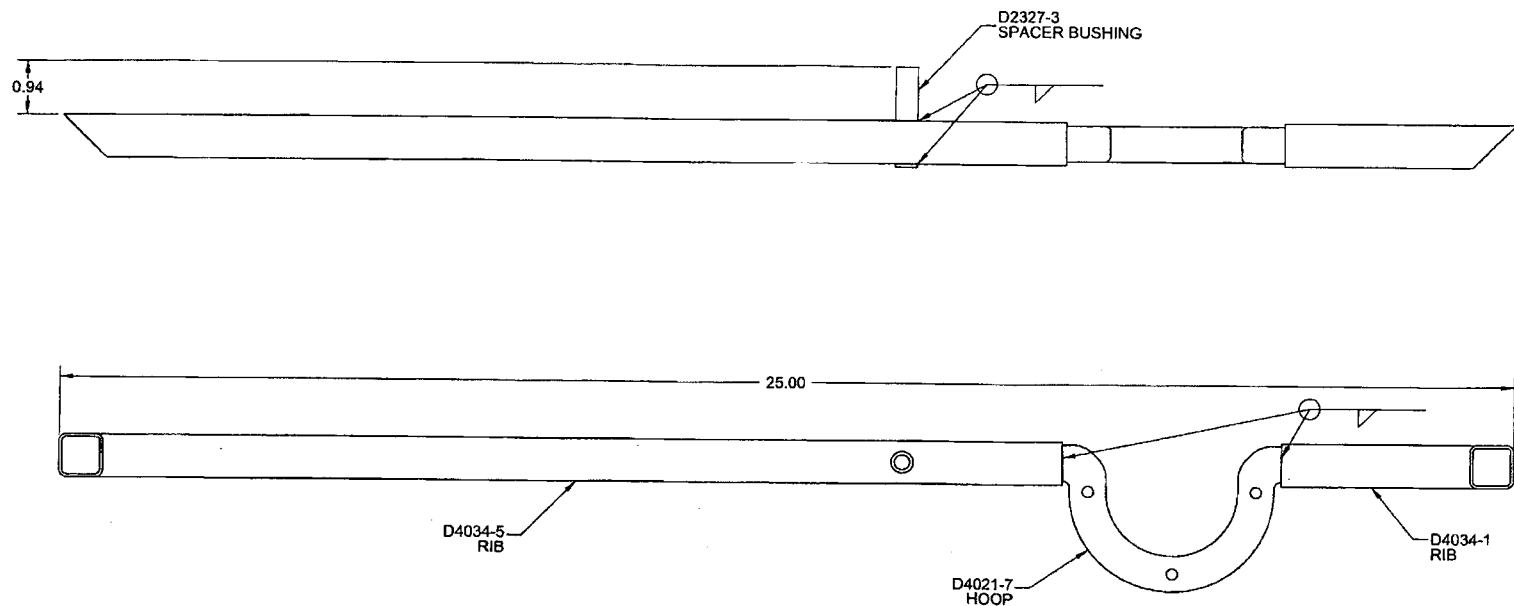
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

81170



D4034-043 FWD UPPER RIB ASSY

RELEASED
2011-01-30

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.58 lbs
 - 8) WELD PER DART QSI 004

| | | | |
|------------|----------|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | SC | DRAWING NO. | REV. B |
| MFG. APPR. | | D4034 | SHEET 3 OF 4 |
| APPROVED | | TITLE | SCALE |
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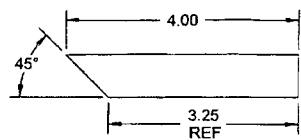
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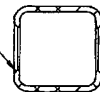
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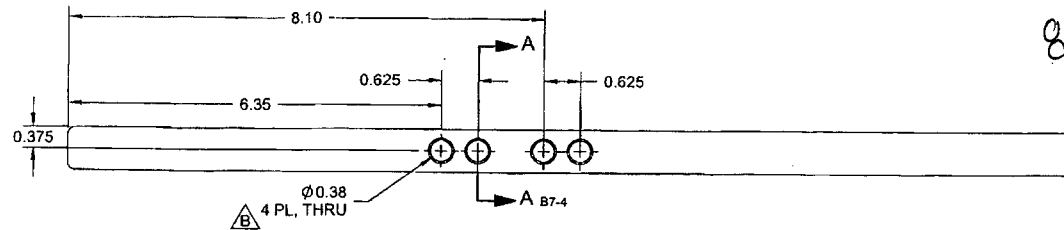
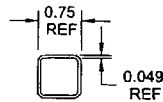


D4034-1 RIB

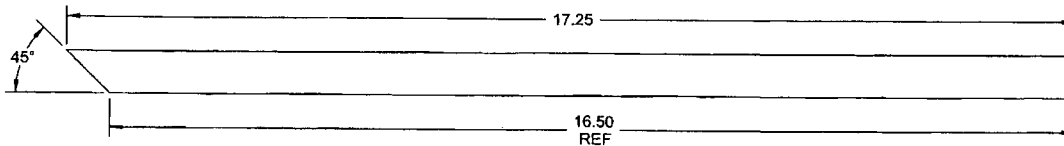
BREAK EDGE
0.030 X 45°
TYP



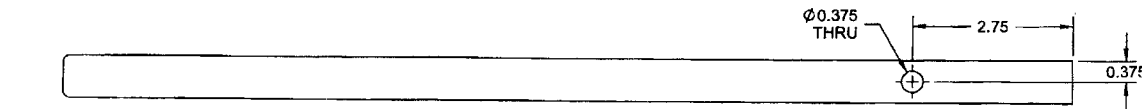
SECTION A-A D4-4



D4034-3 RIB



D4034-5 RIB



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3 & -5: 0.62 lbs

| | | | |
|------------|----------|---|--------------|
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D4034 | SHEET 4 OF 4 |
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2011-01-10

81170

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